

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019250**Date Inspected:** 18-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yan Hua.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Bay 14:

OBG Seg 13BW and Seg 13CW:

Ultrasonic Testing (UT – A, B, C and D scan):

This QA Inspector performed UT; 10 % of the area that has been previously tested and accepted by ABF Quality Control (QC) personnel. This QA inspector generated an UT report on this date. The members are identified as portion butt joint between Bottom panel (BP) to BP – D6 joint and Side Panel (SP) to SP – E7 joint, transverse splice welds located on 13BW+13CW. According to rejection criteria of “D” Scan procedure this QA Inspector did not find any rejected indication at scanning area. The Weld Designation are as follows:

1) OBW13C-001 (BP – D6)

2) OBW13C-002 (SP – E7)

This QA Inspector observed the following work in progress:

OBG Seg 13AE:

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The Flux Cored Arc Welding (FCAW) process on weld joint no: Seg3007AU-066 [Floor Beam (FB) to RS stiffener, partial joint penetration (PJP) weld, at Panel Point (PP): 119.65]. The welder is identified as 069866 and was observed welding in the 3G position. ZPMC QC was identified as Lv Li Qing. The welding variables recorded by QC appeared to comply with Welding Procedure Specification (WPS): B-T-2333-TC-P4-F.

OBG Seg 13BE:

The Shielded Metal Arc Welding (SMAW) process on weld joint nos: SEG3009F-032, 034, 036 and 038 [Floor Beam (FB) to I-rib stiffeners on Bottom Panel (BP); at PP121, fillet welds]. The welders are identified as 201087 and 048047 and were observed welding in the 3G position. ZPMC QC was identified as Lv Li Qing. The welding variables recorded by QC appeared to comply with WPS: B-P-2113-FCM-1.

The SMAW process on weld joint nos: SEG3009H-098, 103, 108 and 113 (I-rib stiffener splice joint on Bottom Panel; at PP120.5, CJP welds). The welder is identified as 043611 and was observed welding in the 3G position. ZPMC QC was identified as Lv Li Qing. The welding variables recorded by QC appeared to comply with WPS: B-P-2213-B-U2-FCM-1.

OBG Seg 13CE:

Repair welding of weld joint no: SEG3011J-403 [Edge Beam (EB) to FB; CJP weld at PP123]. The welder is identified as 054013 and was observed welding in the 3G position. Welding process was identified as SMAW. ZPMC QC was identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair. Repair welding was done as per WRR: B-WR 17142 Rev-0.

Repair welding of weld joint no: SEG3013G-402 (EB to FB; CJP weld at PP123.5). The welder is identified as 054013 and was observed welding in the 3G position. Welding process was identified as SMAW. ZPMC QC was identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-3G(3F)-FCM-Repair. Repair welding was done as per WRR: B-WR 17145 Rev-0.

Repair welding of weld joint no: SEG3011G-069 (on FB; CJP weld at PP123.5). The welder is identified as 054013 and was observed welding in the 3G position. Welding process was identified as SMAW. ZPMC QC was identified as Li Ming Yang. The welding variables recorded by QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per WRR: B-WR 17135 Rev-0.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural

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Materials for your project.

Inspected By: Wadkar,Sailesh

Quality Assurance Inspector

Reviewed By: Patterson,Rodney

QA Reviewer